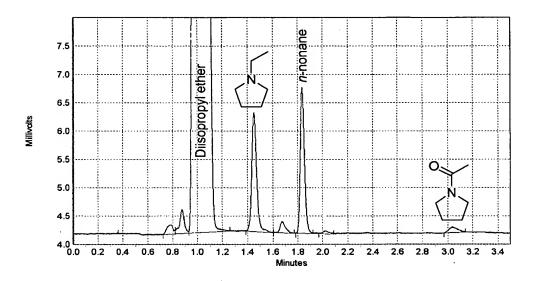
Substitute Specification - Clean Version

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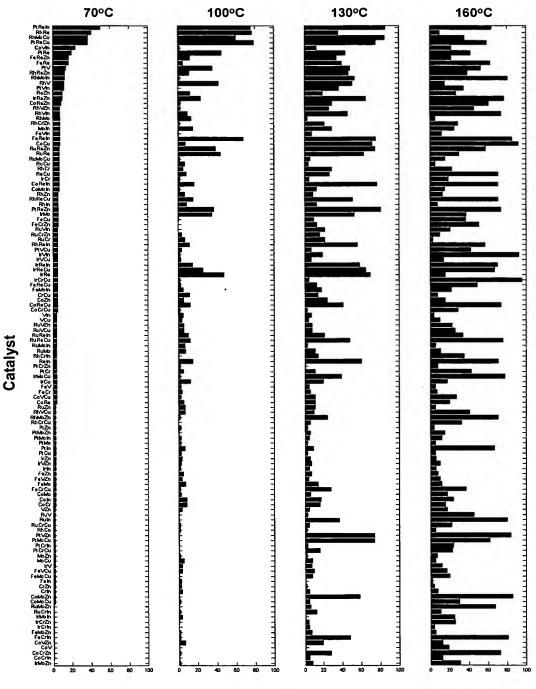


5

FIG. 1

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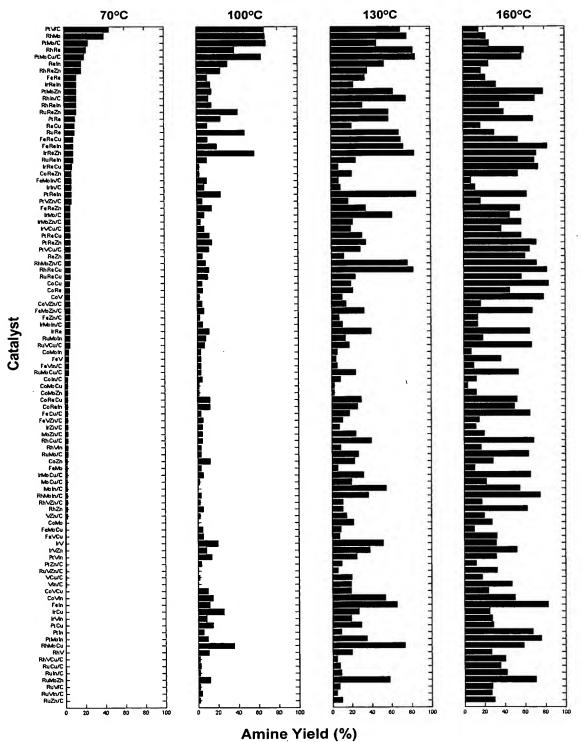
Silica Supported Catalyst



Amine Yield (%)

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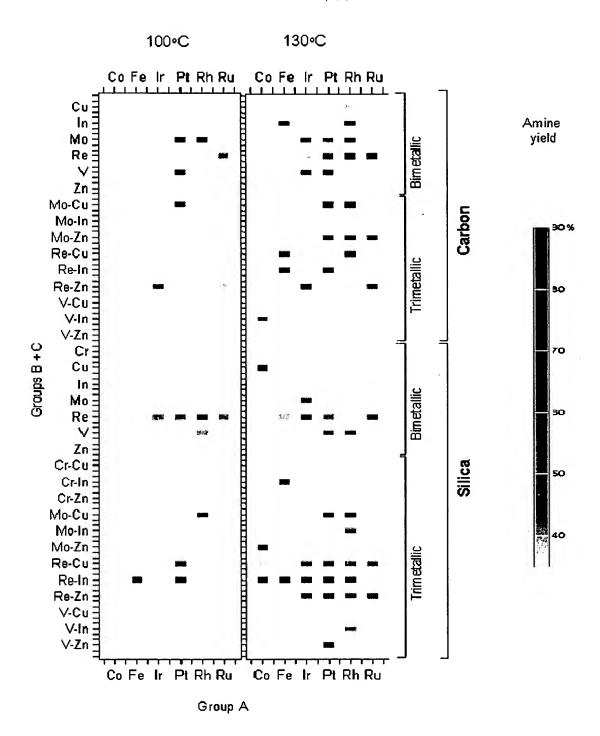


FIG. 4

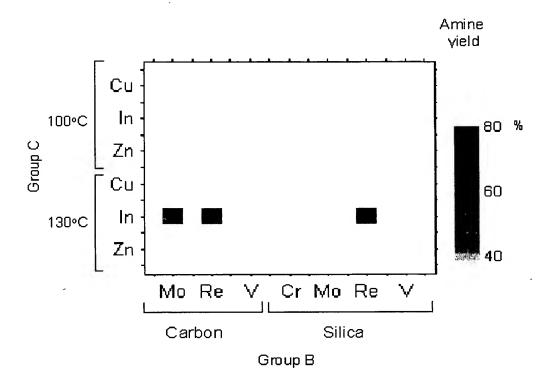


FIG.5

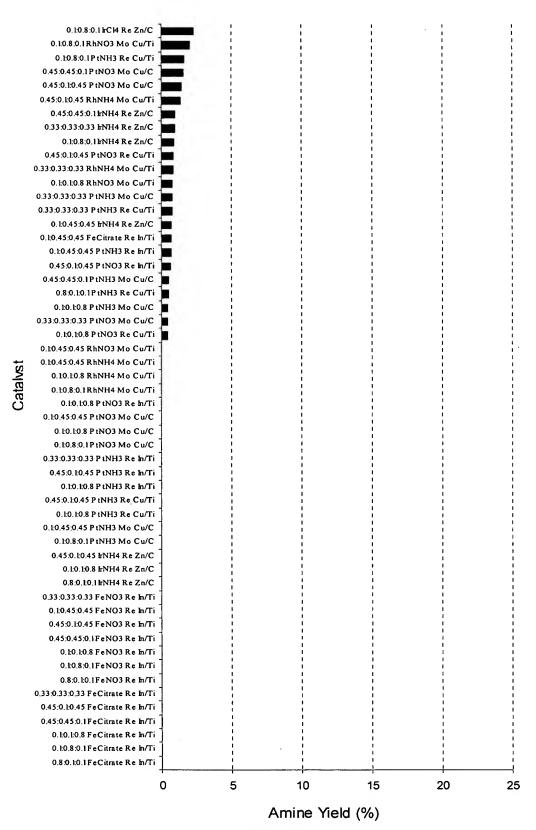


FIG. 6

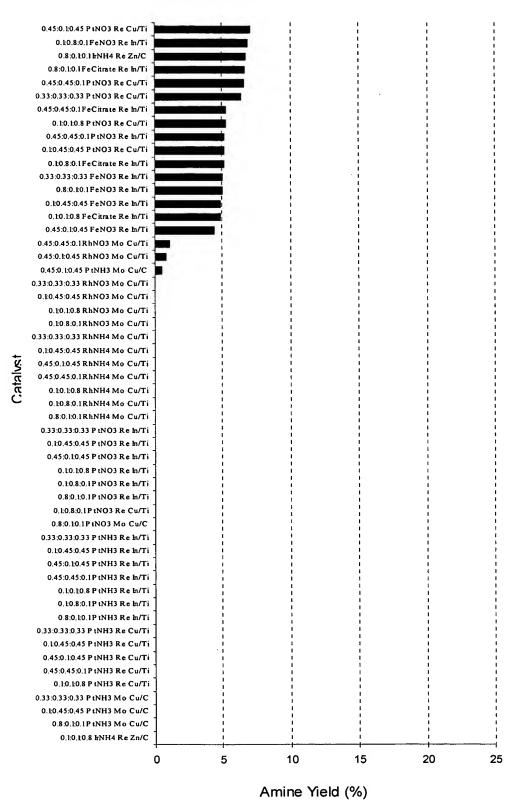


FIG. 7

FIG. 8

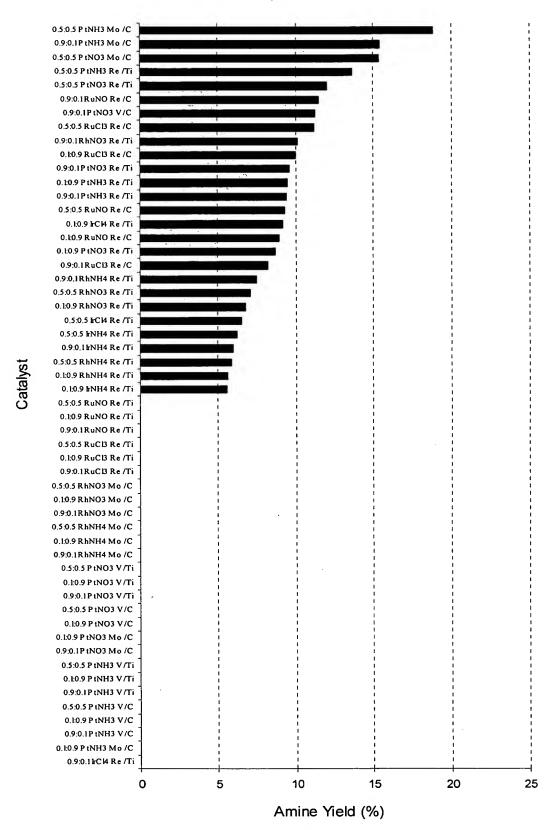


FIG. 9

Substitute Specification - Clean Version

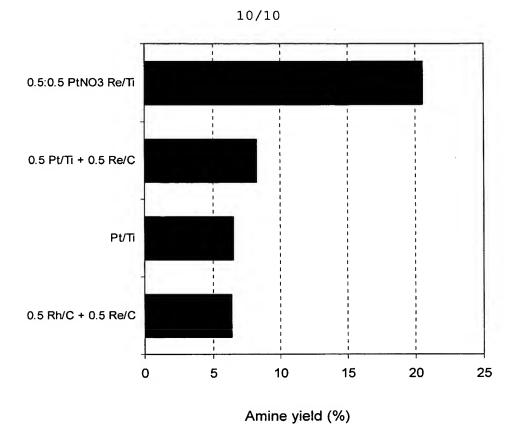


FIG. 10